

Work Order ID 57541

April 8, 2010 8:55:08 AM



Page 1

Item ID: D2976

Accept



Setup Start



Revision ID:

Stop



Item Name: BO 105 Skidtube I Beam

Start Date: 4/08/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/12/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

C2

Date: 10/4/08

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2976

Rev A1

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

Cut D2963-084 extrusion to length: (82.00") ☐ Use Jig DT8546 to drill pilot holes ☐ Open holes to finish size per dwg D2976 ☐ Deburr

Q.m 10-05-210

110

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

Q.m 10-05-210

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

S color 126

70

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 4/12/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location L6

0.00



Packaging

Memo

0.00

Packaging

1 11/05/26

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/26 *[Signature]*
10-5-24
[Signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 57541



Parent Item: D2976

Parent Item Name: BO 105 Skidtube I Beam


Start Date: 4/08/10

Required Date: 4/12/10

Comments: IPP C02.10.30 Re-format KJ

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2963-084  Extrusion		Manufactured	No			110	Each	196.0000	2.1053			

Am 10-05-21

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

HALL

14459

196

196

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

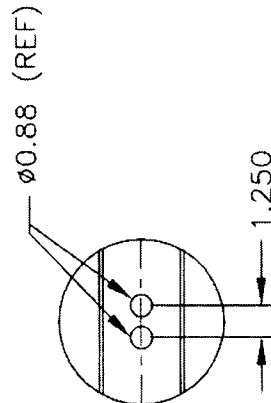
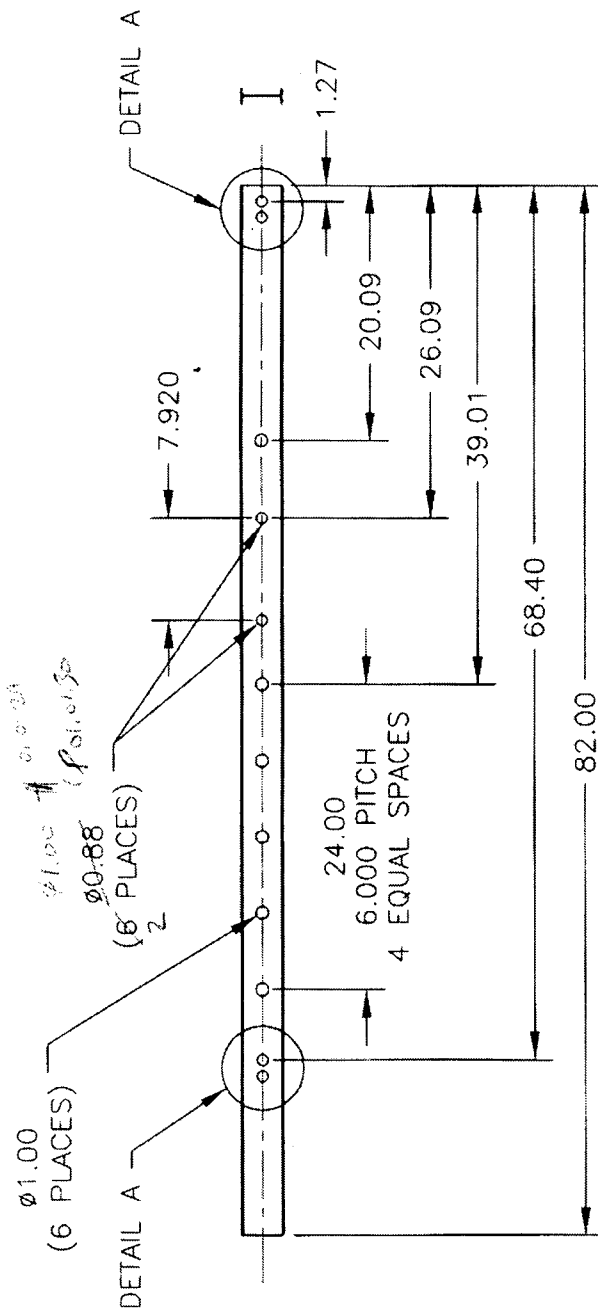
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED #	APPROVED #	DRAWING NO. D2976	REV. A SHEET 1 OF 1
DATE 00.03.14		TITLE WEB	SCALE 1:14
A	00.03.14	NEW ISSUE	
A1	01-01-29	OPEN GRINDS HANDLING HOLES TO $\phi 1.00$	

RELEASED
00.05.11 #



W/D 57541

MAKE FROM D2963-084 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Lean principle

To be able to produce exactly:

- **what is required**
- **when it is required**
- **the quantity required**

by the next step in the process.

Once a job started, it should ideally never stop